

Stop *NR2*

[illegible]

96850

February-07-13 10:38:36 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 2/07/13 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 2/13/13 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00

140

NC BRAKE

0.00

Brake NC

Memo

Brake NC

Bend as per Dwg D4659

150

0.00

150

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

160

0.00

160

Grey Sandtex (Ref: 4.325.6) per QSI005 4.3

0.00

Powdercoat

Memo

Powder Coating

Work Order ID 96850

96850

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Item ID: D4659-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket, LH
 Start Date: 2/07/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 2/13/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
165 *165* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4			
180 *180* Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00				4x			
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

13-2-13
 13/2/14
 130213

Picklist Print

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Page 1

Work Order ID: 96850

Parent Item: D4659-1

Parent Item Name: Bracket, LH

Start Date: 2/07/13

Required Date: 2/13/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 12-06-01 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	329.1001	0.145	0.6105263 0.7			Jm

Location

Loc Qty

Loc Code

MAT020

329.100065

121380

0.000065

122732

32

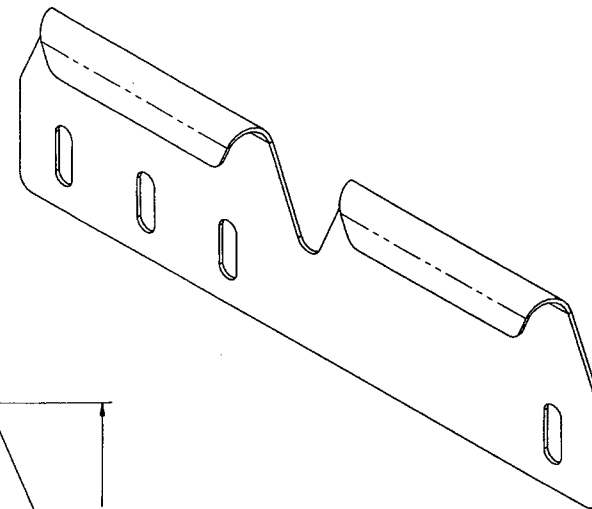
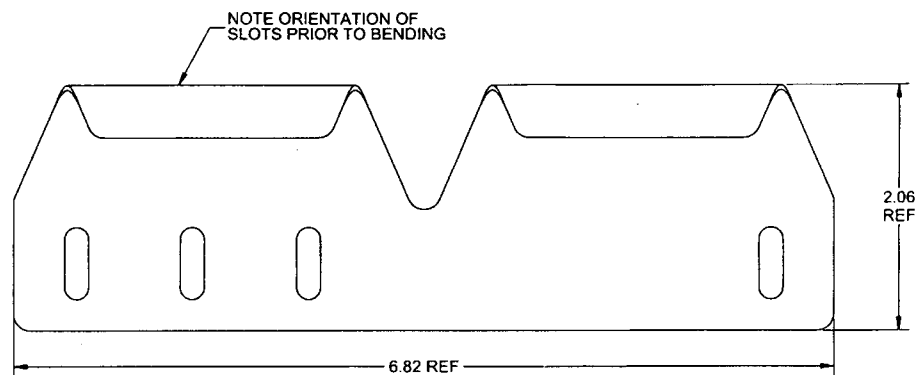
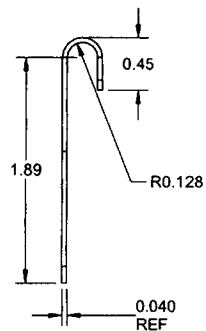
122753

98.8

124029

198.3

124029



D4659-1 BRACKET, LH

RELEASED
2012-06-13

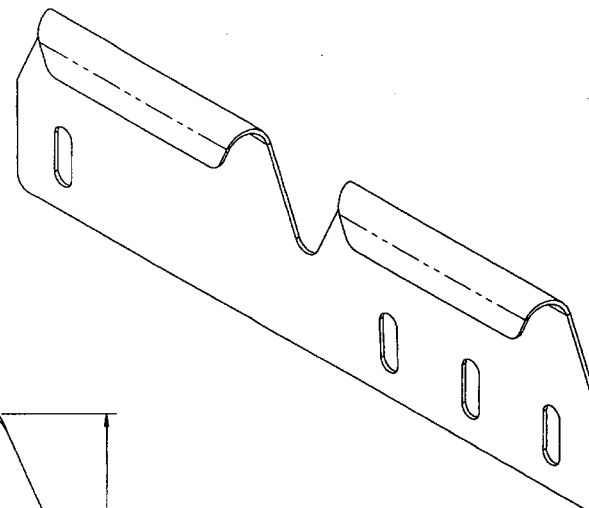
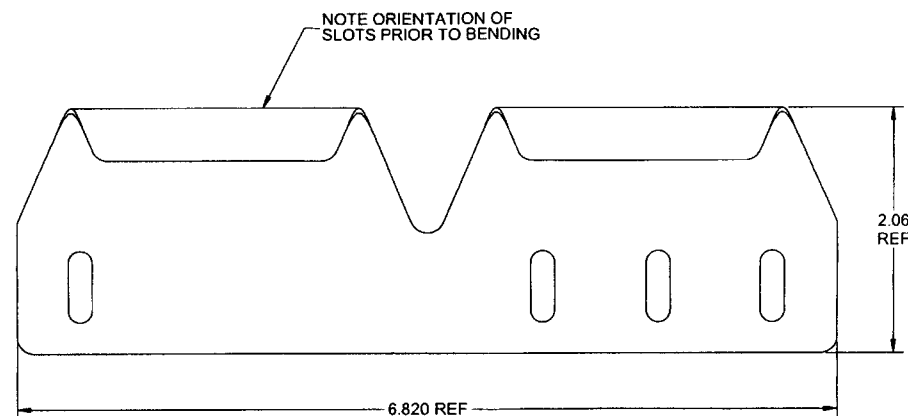
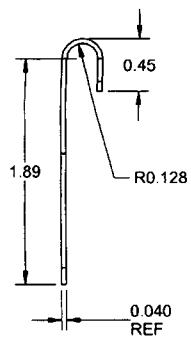
W/O 96850

NOTES:

- 1) MATERIAL: MAKE FROM D4659-1F
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4659-1" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.25 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	RP	12.06.08
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.06.08		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
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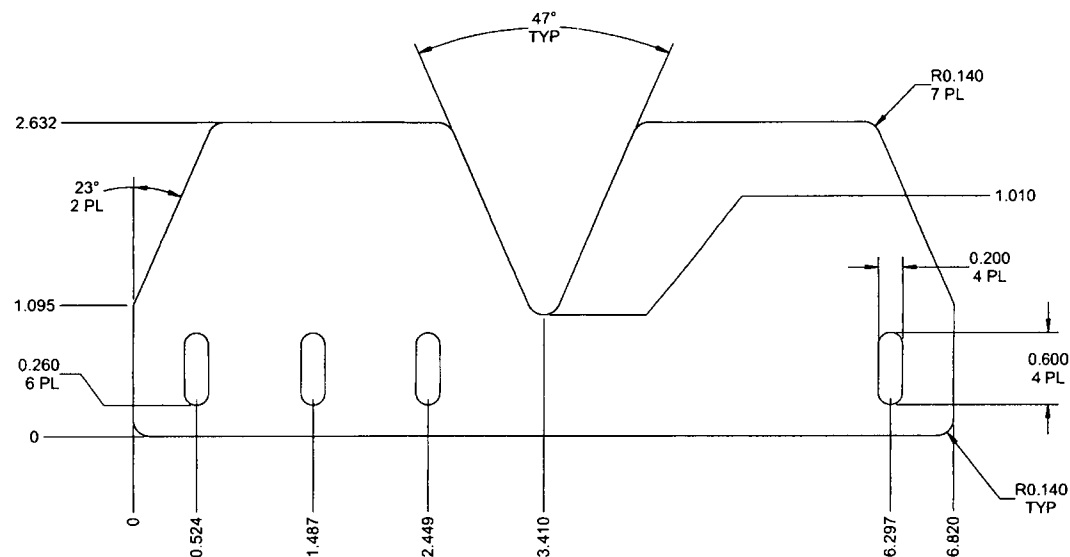
D4659-2 BRACKET, RH

RELEASED
2012-06-13

NOTES:

- 1) MATERIAL: MAKE FROM D4659-1F
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4659-2" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.25 lbs

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D4659-1F BRACKET (FLAT PATTERN)

RELEASED
2012-06-13

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.25 lbs

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